

Work Order ID 128929

128929

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Item ID: D5062-041 Accept *N900040100* Setup Start *NS1*

Revision ID:

Item Name: Bracket Assembly Stop *NS2*

Start Date: 1/28/15 Start Qty: 10.00 *10*

Required Date: 1/28/15 Req'd Qty: 10.00 *10*

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: W Date: _____ Tooling: _____ Date: _____ Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D5062	A								
100	FLOW WATER JET	0.00							
100									
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut D5062-1F as per Dwg								
6061.080"	Dwg Rev: <u>A</u>								
	Prog Rev: <u>A</u>								
	2-Deburr as required								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110									
QC	Memo	0.00							
Quality Control									

(12) _____ DC 15/02/18

(12) _____ DC 15/02/18

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Item ID: D5062-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Bracket Assembly
 Start Date: 1/28/15 Start Qty: 10.00 ***10*** Cust Item ID:
 Required Date: 1/28/15 Req'd Qty: 10.00 ***10*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Chemical Conversion Coat per QSI005 4.1	0.00							
150						12	0	15-3-13	DGC
HandFinish	Memo	0.00							
Hand Finishing									
160	QC7-Inspect Chemical Conversion Coat	0.00							DAG 38 9-89
160						(12)			
QC	Memo	0.00							
Quality Control									MAR 13 2015
170		0.00							
170						12	FF		MAR 16 2015
Small Fab	Memo	0.00							
Small Fab	INSTALL RIVET AS PER DWG								

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Stop ***NR2***

Quality Control

DAS
38
9-89

MAR 17 2015

DAS
38
9-89

MAD 25 2015

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Item ID: D5062-041 Accept ***N900040100*** Setup Start ***NS1***
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 Item Name: Bracket Assembly
 Start Date: 1/28/15 Start Qty: 10.00 ***10*** Cust Item ID:
 Required Date: 1/28/15 Req'd Qty: 10.00 ***10*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
210	Identify as per dwg & Stock Location: <u>st 144</u>	0.00			DAS				
210					27				
Packaging	Memo	0.00			9-23				
Packaging									
									MAR 25 2015
220	QC21- Final Inspection - Work Order Release	0.00							
220									
QC	Memo	0.00							
Quality Control									

MCS 150325

ME
15-3-25

Picklist Print

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Work Order ID: 128929

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Parent Item: D5062-041

D5062-041

Parent Item Name: Bracket Assembly

Start Date: 1/28/15

Required Date: 1/28/15

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP REV:A 14.02.11 NEW ISSUE DD VERF:JLM IPP
REV:B 14.05.28 AS PER DWG REV.A DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M6061T6S.080

Purchased

No

sf

280.1168

3

M6061T6S 080

6061-T6 .080 Sheet

**

DL 15/02/18

Location

Loc Qty

Loc Code

MAT020

280.1168

m130530

67

m130560

213.1168

3.625

MS20470AD4-5

Purchased

No

Each

2,498.000

40

MS20470AD4-5

RIVET, UNIVERSAL HEAD

**

FF

MAR 16 2015

Location

Loc Qty

Loc Code

GA

2248

m128401

2216

m128813

32

ST310

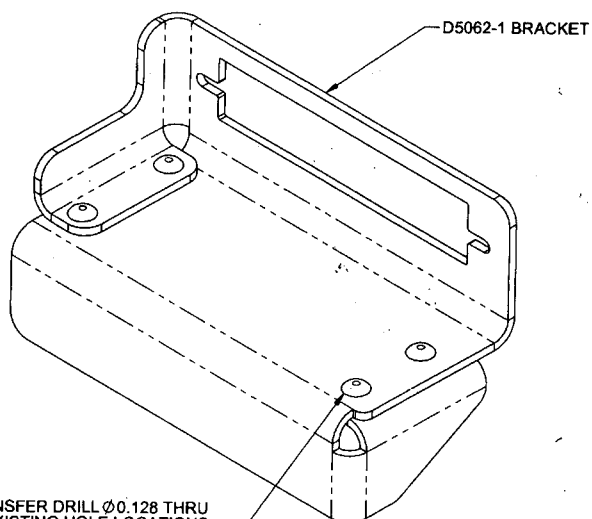
250

m128813

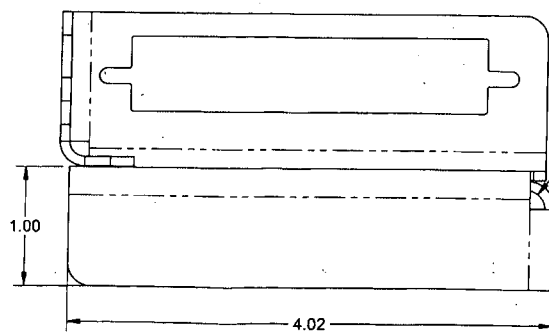
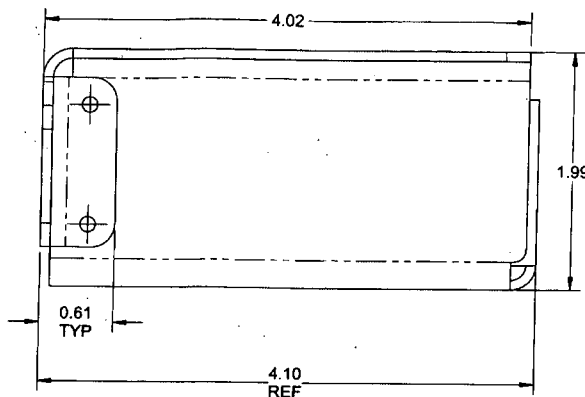
250

40

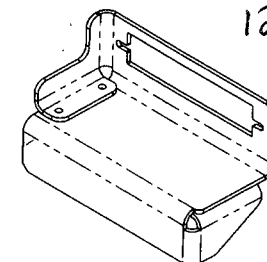
ITEM	QTY-041	P/N	DESCRIPTION
	X	D5062-041	BRACKET ASSY
1	1	D5062-1	BRACKET
2	4	MS20470AD4-5	RIVET, PANHEAD



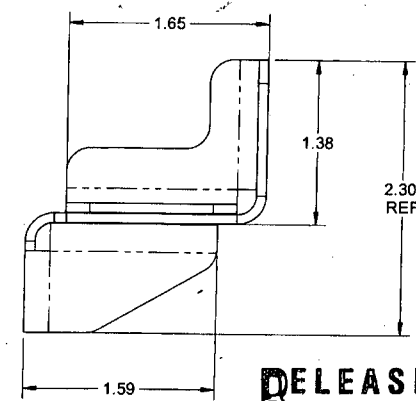
D5062-041 BRACKET ASSY



D5062-1 BRACKET
MAKE FROM D5062-1F



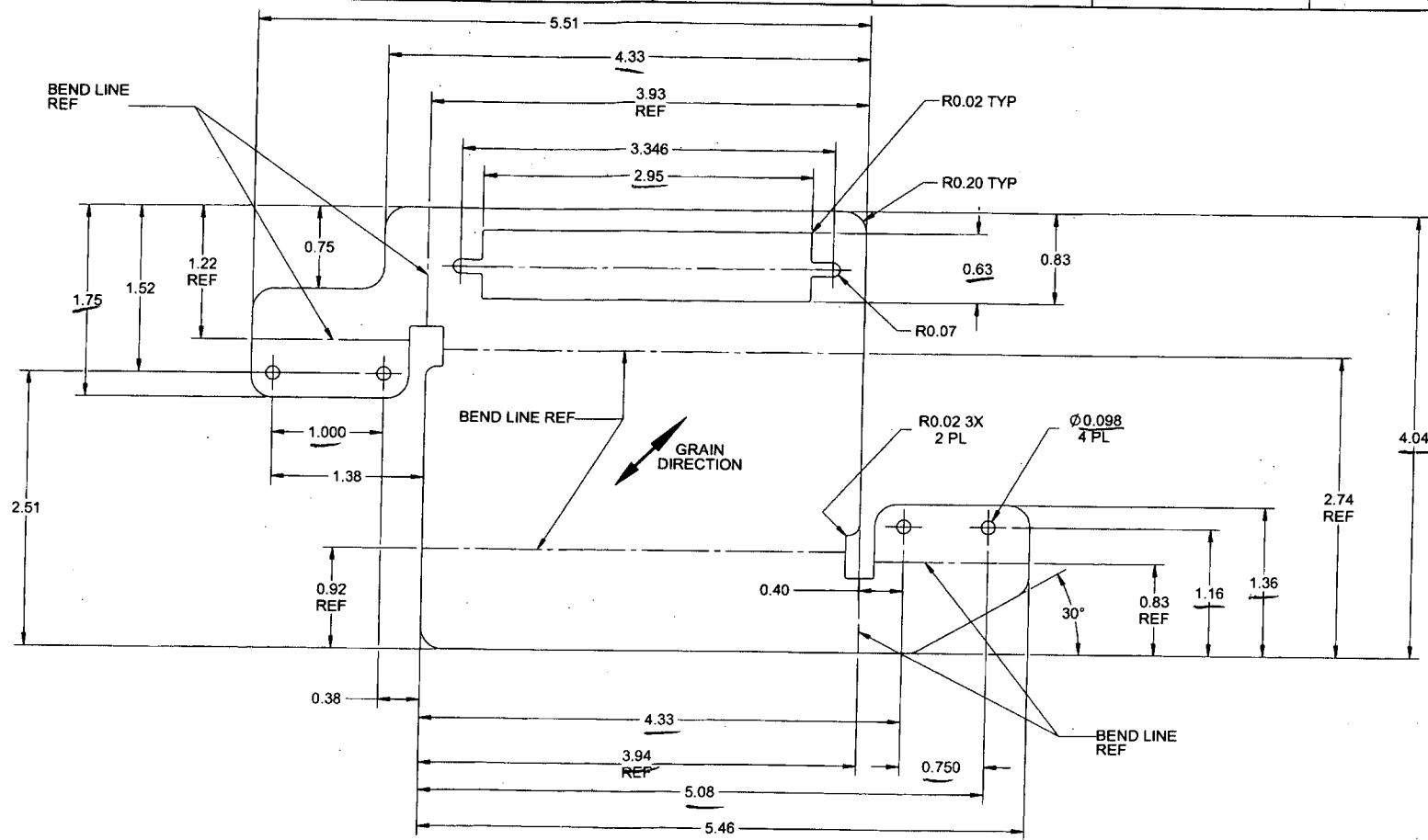
128929
ML5
15-01-29



RELEASED
2014-05-28

- NOTES:
- 1) MATERIAL: MAKE FROM D5062-1F
 - 2) FINISH: D5062-1: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1, D5062-041: PRIME IAW MIL-P-23377J TYPE I CLASS N; 1-2 MIL MAX, AS PER QSI 005.
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D5062-041" PER QSI 044 6.1
 - 7) WEIGHT: 0.13lbs

A NEW ISSUE		DB	14.02.10
REV.	DESCRIPTION	BY	DATE
DESIGN	DB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DB		
CHECKED	DW	DRAWING NO.	REV. A
MFG. APPR.	DD	D5062	SHEET 1 OF 2
APPROVED	MP	TITLE	SCALE
DE APPR.	DS	BRACKET	NTS
DATE 14.02.10		COPYRIGHT © 2014 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



D5062-1F FLAT PATTERN

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.080 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF. DART SPEC. M6061T6S.080)
- 2) FINISH: D5062-1F: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.13 lbs
- 8) ALL NON-DIMENSIONED FEATURES CONTROLLED BY CAD FILE "D5062-1F-A.DXF"

DESIGN	DB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DB		
CHECKED	DW	DRAWING NO.	REV. A
MFG. APPR.	DD	D5062	SHEET 2 OF 2
APPROVED	MP	TITLE	SCALE
DE APPR.	DS	BRACKET	NTS
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2014-05-28

